



Dart Aerospace Ltd.
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Canada

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D350-591-311
Job Sheet 183720



DAS
21
9-06

Part No: D350-591-311

Job Qty: 5 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/25/18

Job Tracking No: AIRBUS

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

6704

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		12/21/18	0.00	0.00	Start Up Large Fab-4		Cpc
110	Large Fab	5 pcs		12/21/18	0.00	4.96	Large Fab 2		gpc
120	QC	5 pcs		12/21/18	0.00	0.00	QC9		SS
130	QC	5 pcs		12/21/18	0.00	0.00	QC5		SS
140	HandFinish	5 pcs		12/21/18	0.00	0.92	HandFinish1		DR 18/10/31
150	QC	5 pcs		12/21/18	0.00	0.00	QC7-2		gpc
180	Large Fab	5 pcs		12/21/18	0.00	4.96	Large Fab 2		DAS
190	QC	5 pcs		12/21/18	0.00	0.00	QC10		38 DAS
200	QC	5 pcs		12/21/18	0.00	0.00	QC5		9-88 38
210	HandFinish	5 pcs		12/21/18	0.00	0.92	HandFinish1		DR 18/11/18
220	Powdercoat	5 pcs		12/21/18	0.00	1.45	Powdercoat1		DR 18-11-19
230	HandFinish	5 pcs		12/21/18	0.00	0.92	HandFinish3		DR 18-11-19
240	QC	5 pcs		12/21/18	0.00	0.00	QC3		38
250	Packaging	5 pcs		12/21/18	0.00	0.00	Packaging1-3		9-88
260	QC	5 pcs		12/21/18	0.00	0.00	QC4		DAS 21
270	Packaging	5 pcs		12/21/18	0.00	0.00	Packaging3-1		DEC 11 2018
275	DC	5 pcs		12/21/18	0.00	0.00	DC		DEC 11 2018
280	QC21-FG	5 Ea		12/21/18	0.00	0.00	QC21		DEC 11 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod

6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:50 OVEN TEMPERATURE: 320 FINISH TIME: 9:20

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	5108640
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	5121130

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging
D2618	Bushing	10 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging

③ S110545 ④ S126166 ⑤
 5113167
 5117999
 5101329
 5115326
 5098504
 5116213
 5118035
 5104552x6 5104554x6
 5113205
 5114310x1 5118822x5
 5094592
 5104736
 5043892
 5098283
 5096780
 5050003

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	111	0
	D3219-1	10	105	0
	D3272-1	5	1	0
180-Large Fab	D3065-041	5	18	0
	D3066-1	10	130	0
250-Packaging	MS20600-AD4W4	80	245	0
	AN3-35A	10	373	0
	AN4-13A	40	774	0
	AN5-36A	10	318	0
	D2230-3	20	179	0
	D2618	10	167	0
	D2856-400-720	10	226	0
	D3235-1	10	259	0
	D3278-041	5	0	0
	MS21042L3	10	3,077	0
	MS21042L4	40	4,463	0
	MS21042L5	10	832	0
	NAS1149D0363J	20	2,097	0
	NAS1149D0463J	80	6,598	0
	NAS1149D0563J	20	1,526	0

Part Specifications

Specifications could not be found.

Plex 9/25/18 10:25 AM Dart.lajeunesse.marie



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 CANADA
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 www.dartaerospace.com

Container No: S121637



Part: D350-591-311

Job No: 183720

Serial No/Batch: S121637

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 Date 11/25/11 FAA STC SH967NE 04/12/21, BRAZIL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

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